

Date: Wednesday, 2/20/2008 4:19:26 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI-UTILITY BASKET RH
 Job Number : 37515
 Estimate Number : 13190
 P.O. Number :
 This Issue : 2/20/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D205541046
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : IIN D205-541 REV G U/R
 Previous Run : 37514 Drawing Revision : G
 Material :
 Due Date : 3/14/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A new issue 08-02-15 verified by:

POSITIVE
RECALLPOSITIVE
RECALL

08-03-12

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD205-541-046 CHG001

08/03/15

2.0 D3712042 LOW PROFILE BASKET BASE ASSEMBLY

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
LOW PROFILE BASKET BASE ASSEMBLY

B37524

ml 08/03/14

3.0 D3713042 LID ASSEMBLY

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
LID ASSEMBLY

B37524

ml 08/03/14

4.0 D2258300 Placard

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Placard
Batch: B37538

AS

08/03/14

(X1)

5.0 D2332041 Lid Prop Assembly 6.69"

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lid Prop Assembly 6.69"
Batch: 35718

AS

08/03/14

(X1)

6.0 D2530 Handle Weldment

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Handle Weldment
Batch: 36657

AS

08/03/14

(X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:19:26 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37515

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: 36397

AS 08/03/14

(XU)

8.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: 36853

AS 08/03/14

(XU)

9.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bumper

Batch: 21139

AS 08/03/14

(XU)

10.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 106815

AS 08/03/14

(XU)

11.0

AN420A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Batch: 105653

AS 08/03/14

(XU)

12.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: 104937

AS 08/03/14

(XU)

13.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: 104547

AS 08/03/14

(XU)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/03/14	11	Use AW4-201 Instead AW4-17A M106895 M106432 AN960JD416L Per D2332-041 qty 2 M106785	SAB	08/03/15	3	AS 06.03.14	S 08/03/14
		Removed 2 AN960JD416					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:19:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37515

Part Number: D205541046

Job Number:



Seq. #:	Machine Or Operation:	Description :
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14.0	AN517A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: 107247

AS 08/03/14 (X)

15.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: 106277

AS 08/03/14 (X)

16.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: 106654

AS 08/03/14 (X)

17.0	AN9704	Washer
------	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: 105442

AS 08/03/14 (X)

18.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: M106242

AS 08/03/14 (X)

19.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Nut

Batch: M105938

AS 08/03/14 (X)

20.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M106277

AS 08/03/14 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:19:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37515

Part Number: D205541046

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

21.0	MS20600AD4W3	Cherry Rivets
------	--------------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: M18071

AS 08/03/14 (X)

22.0	D37231	FWD PLATE
------	--------	-----------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

FWD PLATE

B37900 * new Batch

AS 08/03/14 (X)

23.0	D37571	Blanking Plate
------	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Blanking Plate

37815

AS 08/03/14 (X)

24.0	AN311A	Bolt
------	--------	------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

M17506

AS 08/03/14 (X)

25.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

M100552

AS 08/03/14 (X)

26.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
------	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg.

ml 08/03/14 X

27.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

AS 08/03/14

08/03/14 (X)

28.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/03/15	24	change AW3-10A for AW3-11A M14820 add AW960508 2x M106918	SB	08/03/14	6	MS 08.03.14	08/03/14
08/03/15		AW					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:19:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37515

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D21991

Struts, 19"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Struts, 19"

Batch: 28996

AS

08/03/14

(X1)

30.0

D219923

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: 29387

AS

08/03/14

(X1)

31.0

D219925

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: 37537

AS

08/03/14

(X1)

32.0

D2498

Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Bracket

Batch: 27683

AS

08/03/14

(X1)

33.0

D2499

Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Bracket

Batch: 27501

AS

08/03/14

(X1)

34.0

D2515

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: 29138

AS

08/03/14

(X1)

35.0

D30521

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Lug

Batch: 28522

AS

08/03/14

(X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:19:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37515

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 102140

AS

08/03/14 (X1)

37.0

AN412A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Batch: 105143

AS

08/03/14 (X1)

38.0

AN413A

Bolt



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Bolt

Batch: 106993

AS

08/03/14 (X1)

39.0

AN414A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 105653

AS

08/03/14 (X1)

40.0

AN57A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: 106785

AS

08/03/14 (X1)

41.0

AN513A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: 104936

AS

08/03/14 (X1)

42.0

AN960JD416

Washer



Comment: Qty.: 27.0000 Each(s)/Unit Total : 27.0000 Each(s)

Washer

106277

AS

08/03/14 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 08/03/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:19:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37515

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch:

M100654

DS

08/03/14 (XU)

44.0

MS21042L4

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Batch:

M105938

DS

08/03/14 (XU)

45.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch:

M106277

DS

08/03/14 (XU)

46.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

DS

08/03/15 (XU)

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-541-044

Location:

PPP Rev:

DAR

DS 08/03/17 (1)

48.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DS 08/03/17

Job Completion



4 08/03/17

POSITIVE RECALL

EFFECTIVE 08-02-21 AUTH L

RELEASED DATE 08-03-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

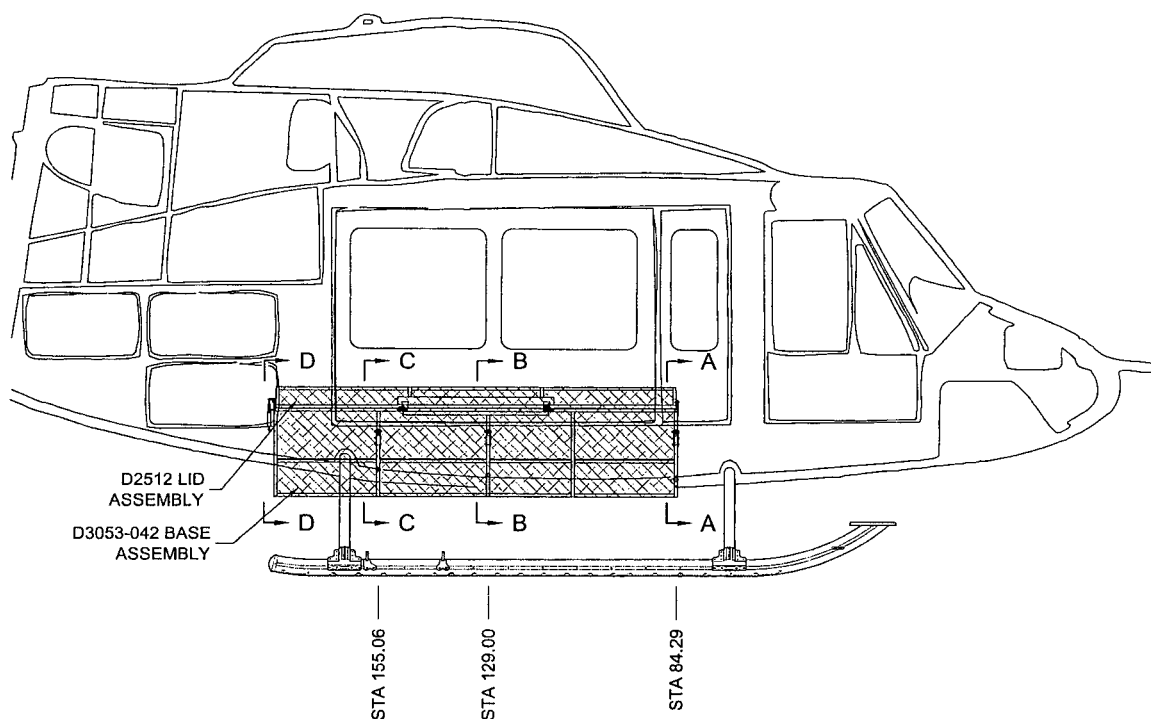


Figure 1a - D205-541-044 Heli-Utility-Basket™ - Side View Shown
(D205-541-043 Opposite)

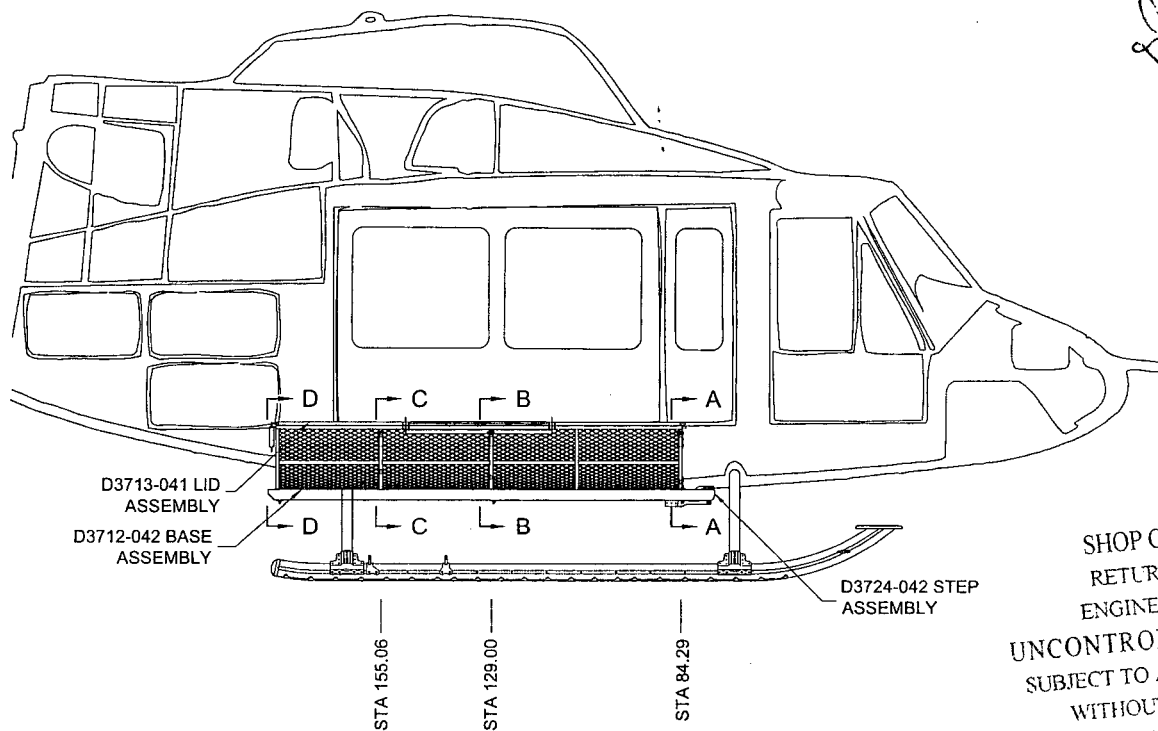


Figure 1b - D205-541-046 Heli-Utility-Basket™ - Side View Shown
(D205-541-045 Opposite)

PRELIMINARY ISSUE
455 02.21.08

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WITHOUT NOTICE
WORK ORDER
NO. 37515

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OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: G

Date: 08.02.04

- 3.2.4 Reposition the step assembly with the basket and install as shown in Figure 12. Torque the #10 fasteners to 15-25 in-lbs (N-m).

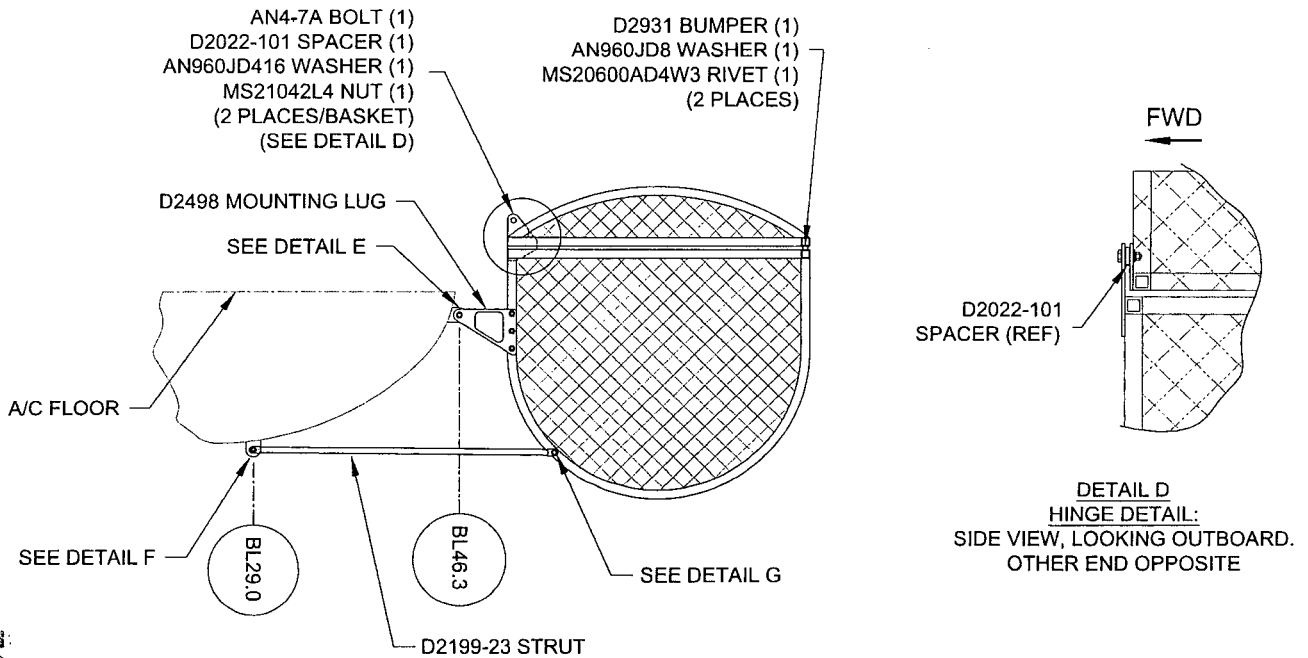


Figure 2a - Section A-A Looking Fwd at STA 84.29
(D205-541-044 Shown; D205-541-043 Opposite)

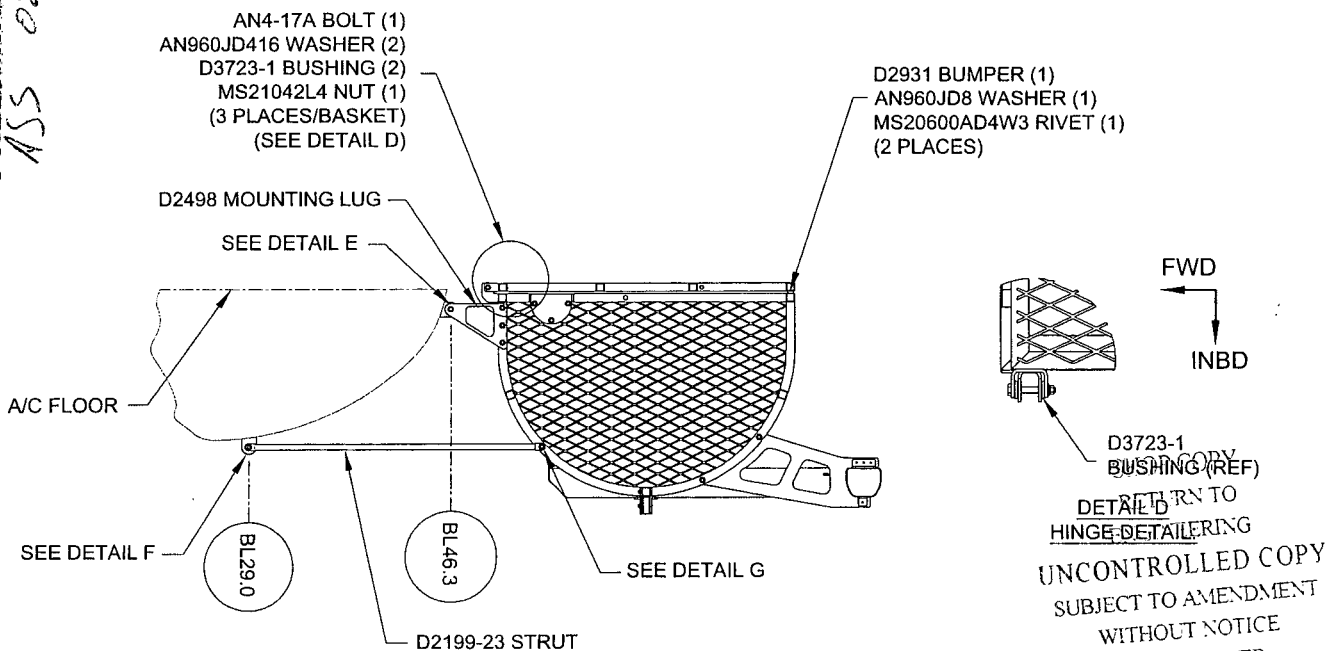


Figure 2B - Section A-A Looking Fwd at STA 84.29
(D205-541-046 Shown; D205-541-045 Opposite)

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Revision: **G**

Date: 08.02.04

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ASS 02.12.08

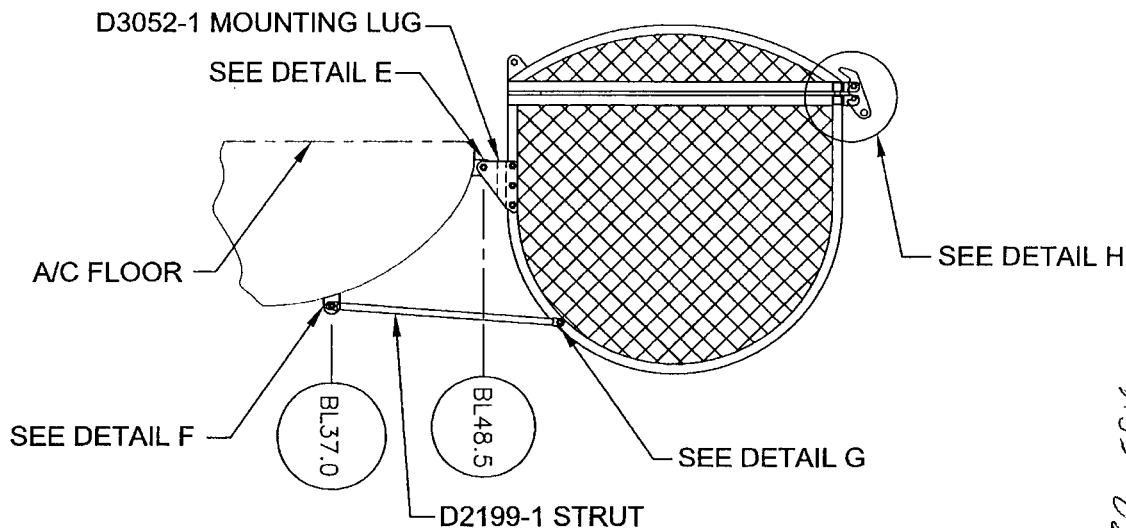


Figure 3a – Section B-B Looking Fwd at STA 129.00
(D205-541-044 Shown; D205-541-043 Opposite)

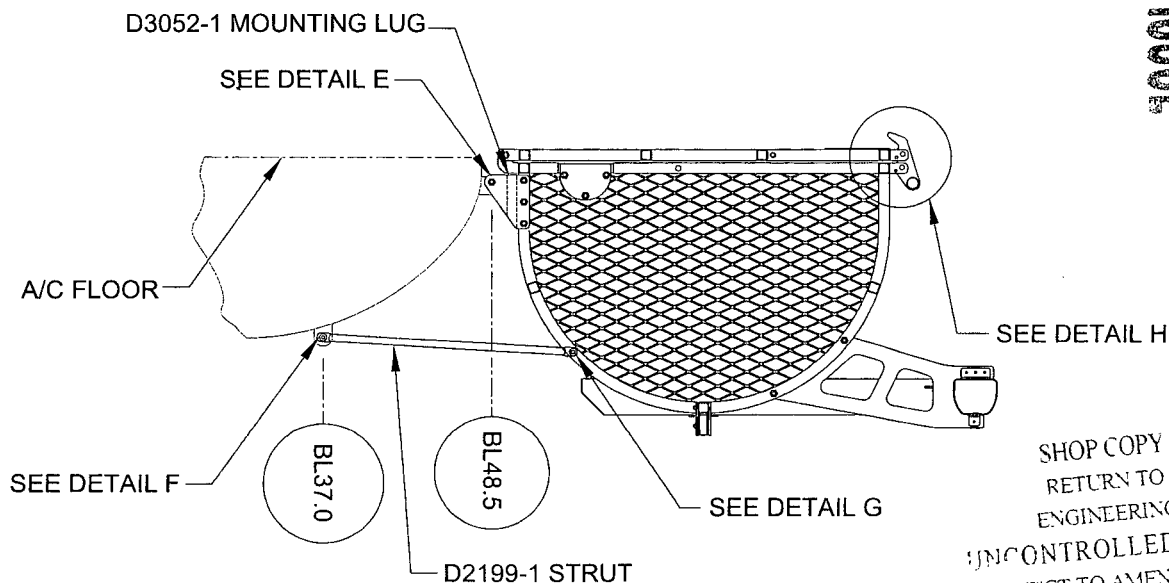


Figure 3b – Section B-B Looking Fwd at STA 129.00
(D205-541-046 Shown; D205-541-045 Opposite)

02.21.08
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 NO. 37515

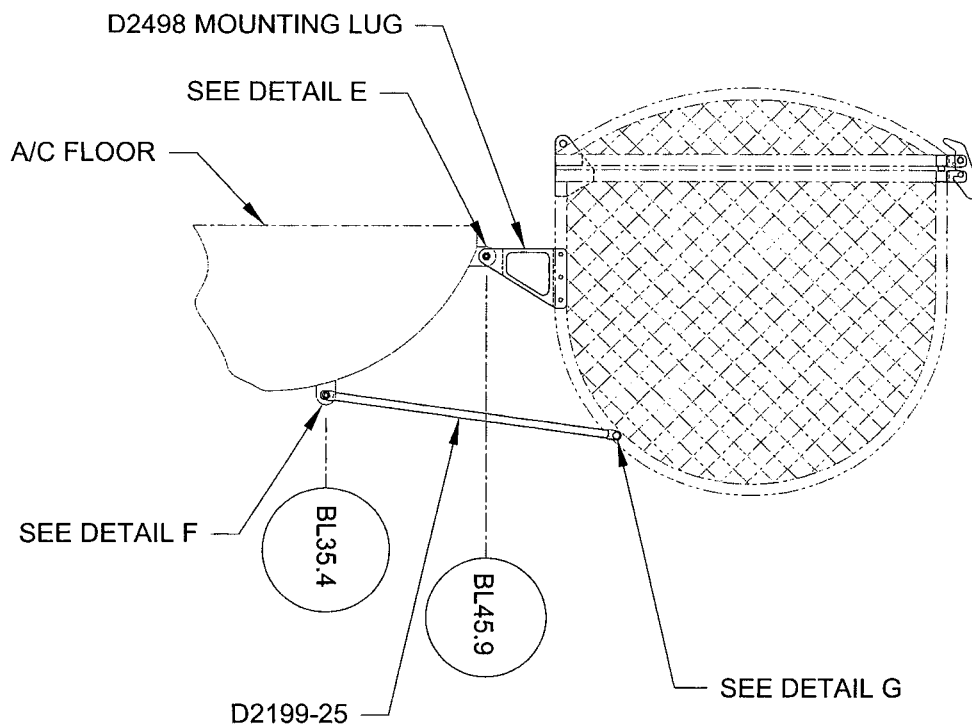


Figure 4a – Section C-C Looking Fwd at STA 155.06

(D205-541-044 Shown; D205-541-043 Opposite)

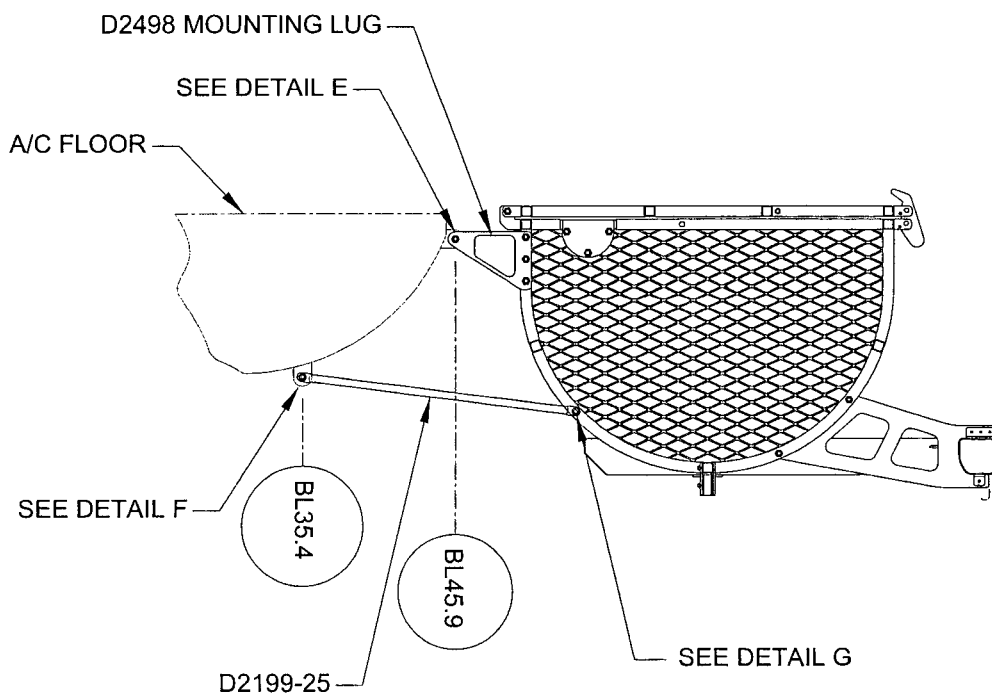
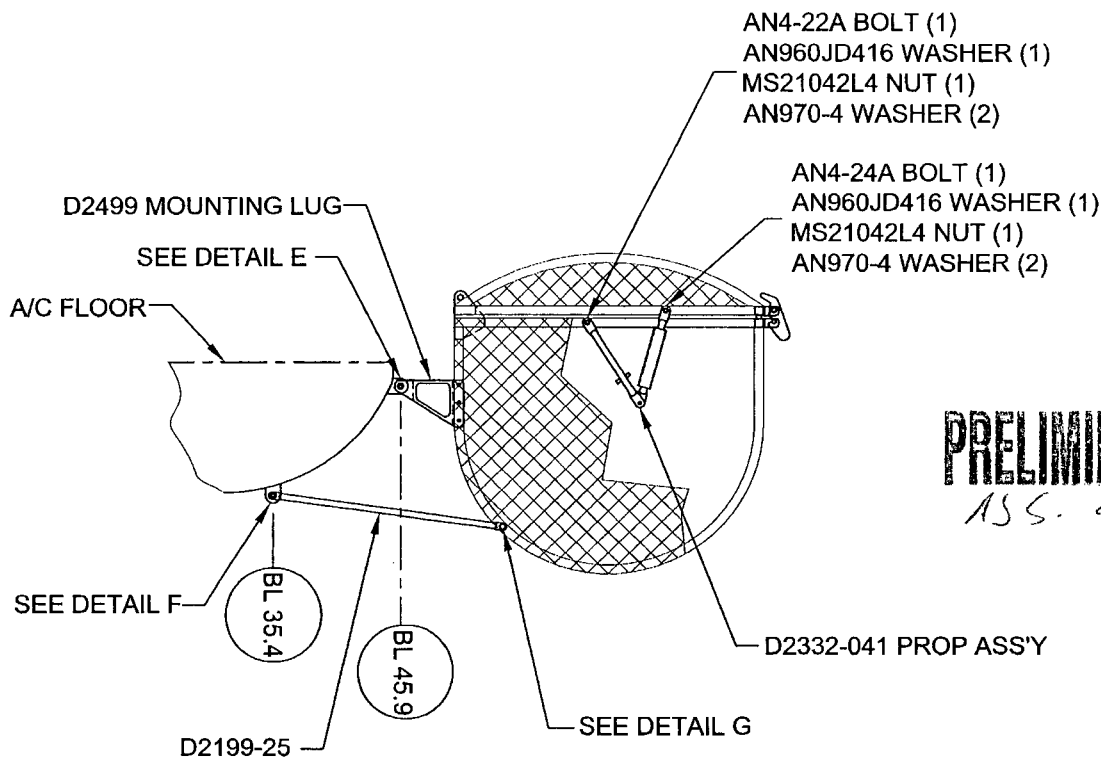


Figure 4b – Section C-C Looking Fwd at STA 155.06

(D205-541-046 Shown; D205-541-045 Opposite)

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MS 02.21.08

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ASS. 02.21.08

Figure 4a – Section C-C Looking Fwd at STA 180.08

(D205-541-044 Shown; D205-541-043 Opposite)

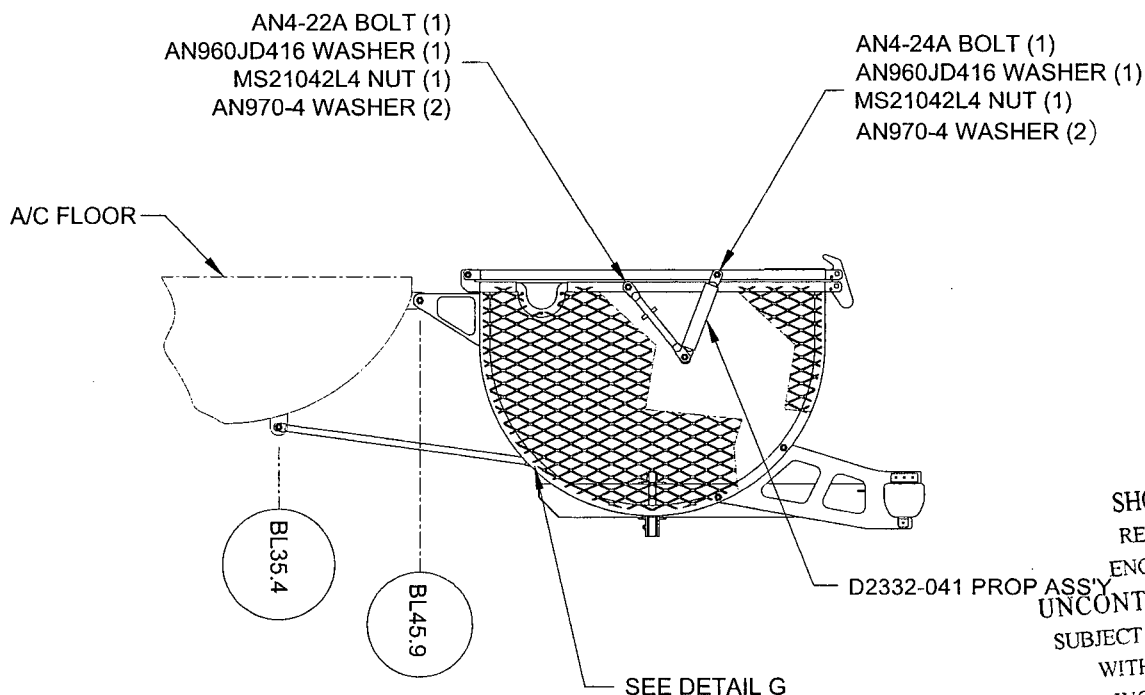


Figure 4b – Section C-C Looking Fwd at STA 180.08

(D205-541-046 Shown; D205-541-045 Opposite)

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WORK ORDER
NO. 37515

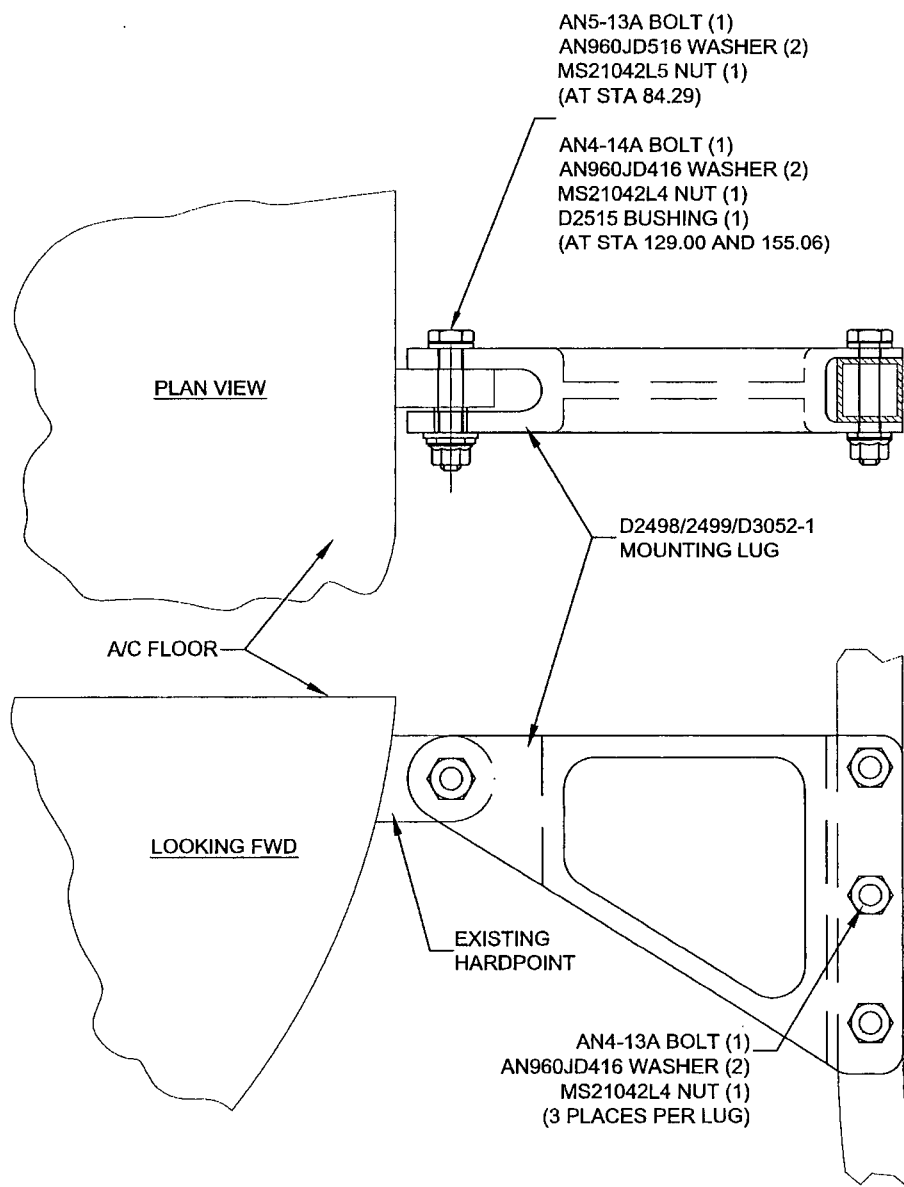


Figure 5 – Detail 'E' Mounting Lug Installation

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NO. 37515

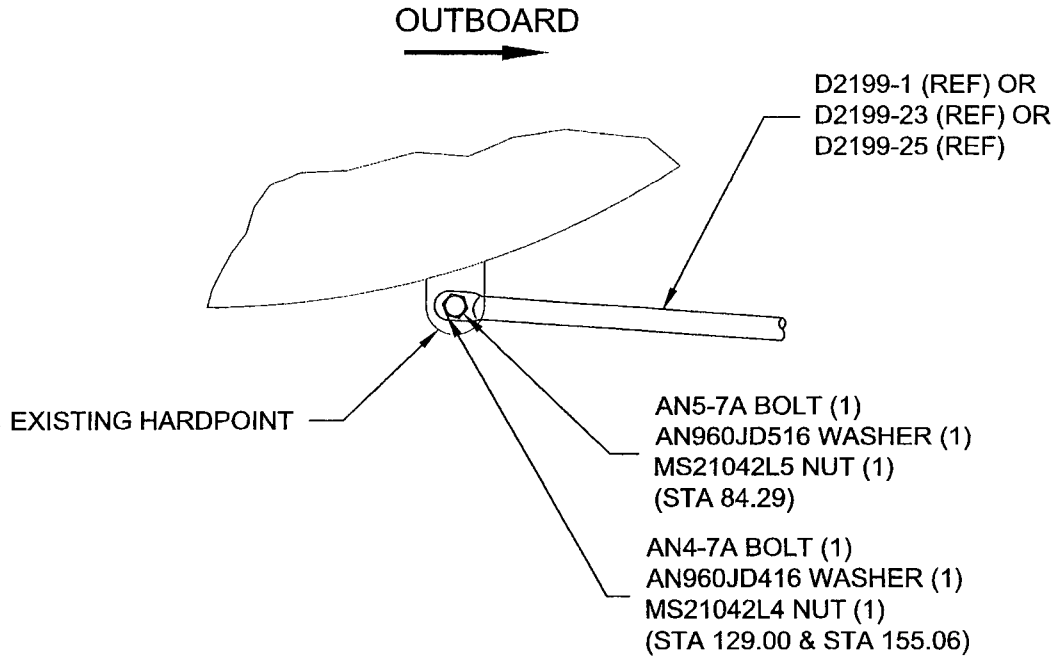


Figure 6 – Detail 'F' Strut to Hardpoint Attachment

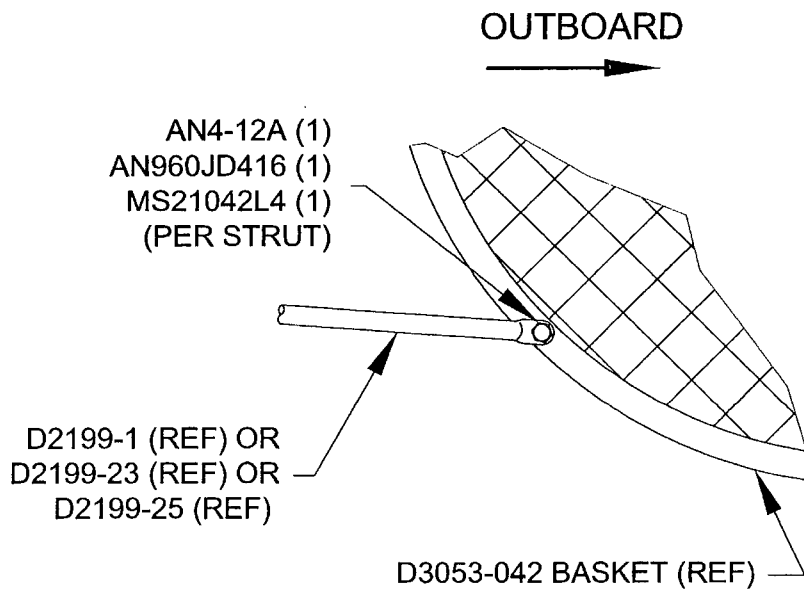


Figure 7 – Detail 'G' Strut to Basket Attachment

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WORK ORDER
NO. 37515

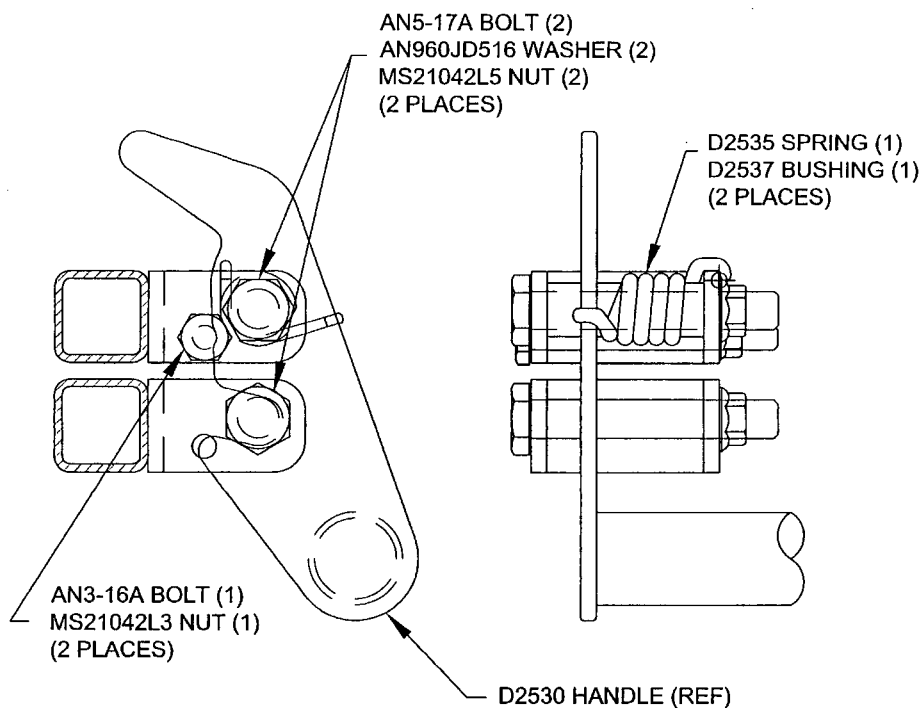


Figure 8 – Detail 'H' Handle Assembly

Figure 9 – Mesh Removal

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ASS 02.21.08

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WORK ORDER
NO. 37515

Date: Wednesday, 2/20/2008 4:19:26 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI-UTILITY BASKET RH
 Job Number : 37515
 Estimate Number : 13190
 P.O. Number :
 This Issue : 2/20/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run : 37514
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A new issue 08-02-15 verified by:

Part Number : D205541046
 Drawing Number : IIN D205-541 REV G 012
 Project Number :
 Drawing Revision : G
 Material :
 Due Date : 3/14/2008 Qty: 1 Um: Each

Paulini

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD205-541-046 CHG001

2.0 D3712042 LOW PROFILE BASKET BASE ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 LOW PROFILE BASKET BASE ASSEMBLY

3.0 D3713042 LID ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 LID ASSEMBLY

4.0 D2258300 Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Placard
 Batch: _____

5.0 D2332041 Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Lid Prop Assembly 6.69"
 Batch: _____

6.0 D2530 Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Handle Weldment
 Batch: _____

REFERENCE ONLY

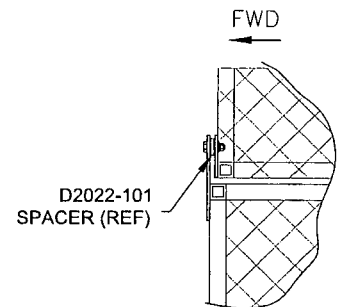
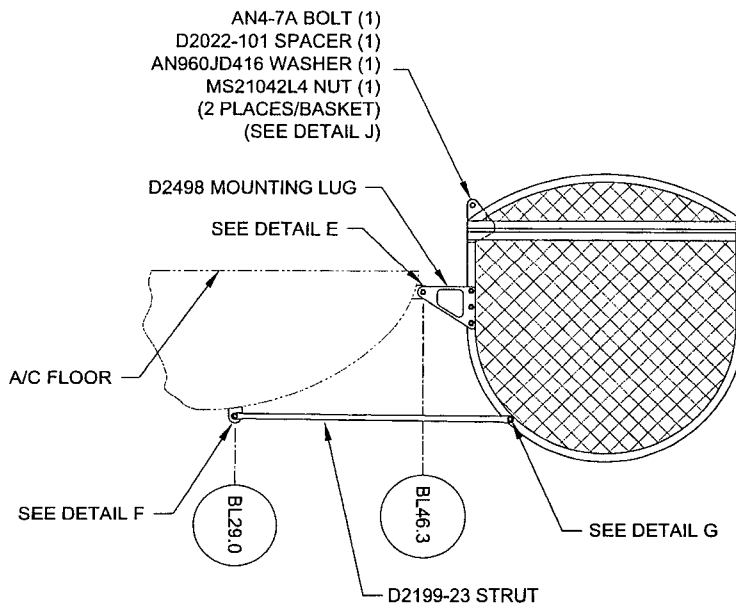


Figure 2a - Section A-A Looking Fwd at STA 84.29
(D205-541-044 Shown; D205-541-043 Opposite)

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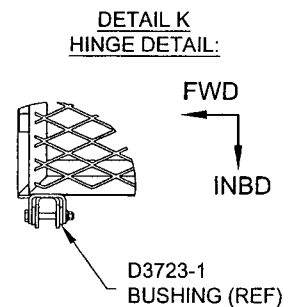
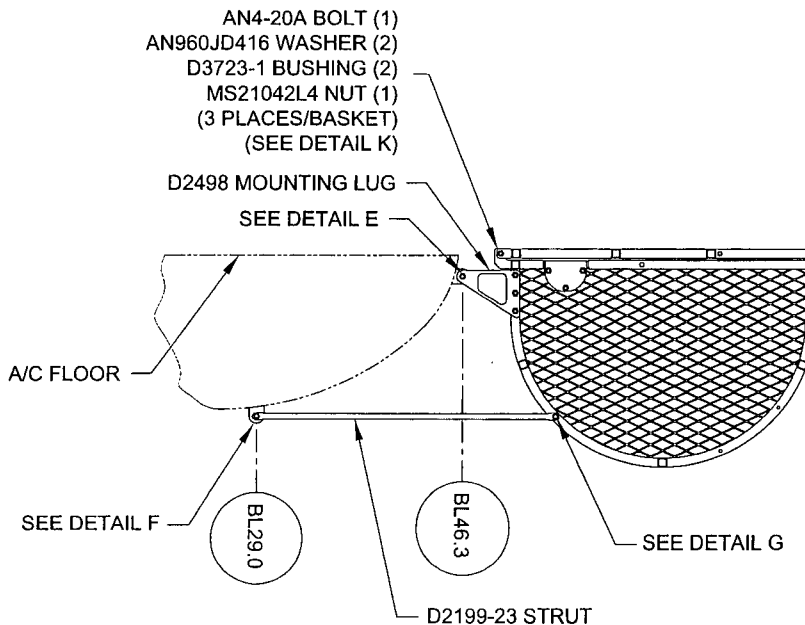


Figure 2b - Section A-A Looking Fwd at STA 84.29
(D205-541-046 Shown; D205-541-045 Opposite)

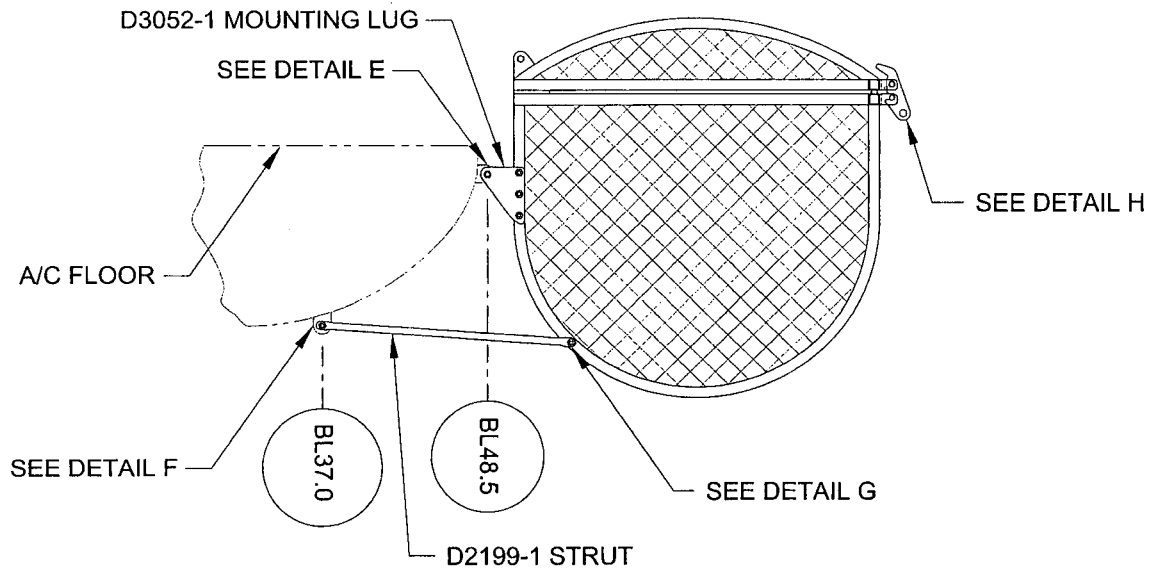


Figure 3a – Section B-B Looking Fwd at STA 129.00
(D205-541-044 Shown; D205-541-043 Opposite)

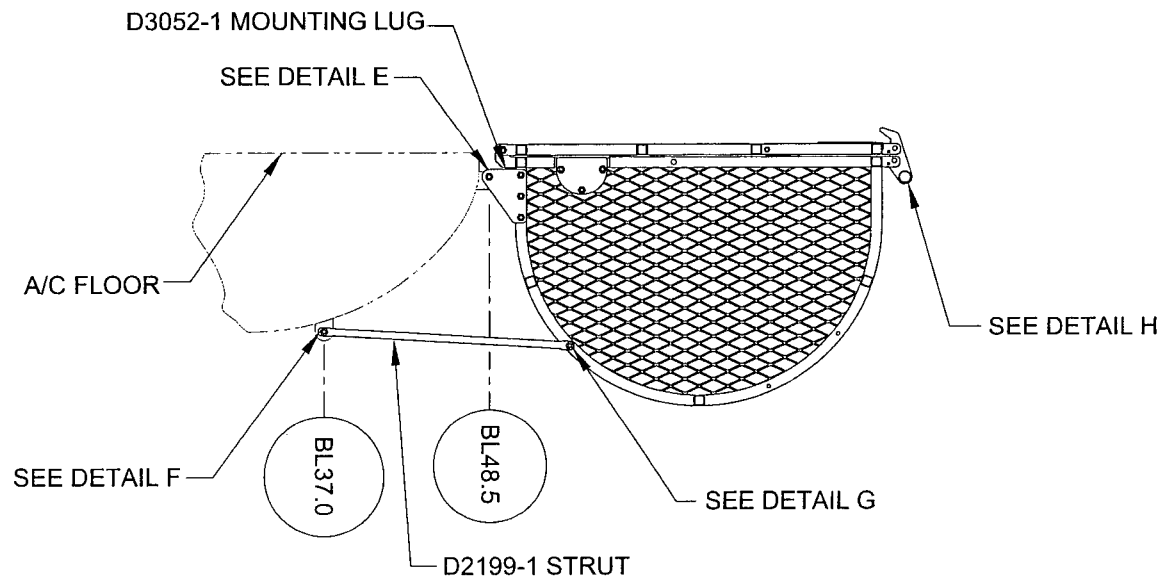


Figure 3b – Section B-B Looking Fwd at STA 129.00
(D205-541-046 Shown; D205-541-045 Opposite)

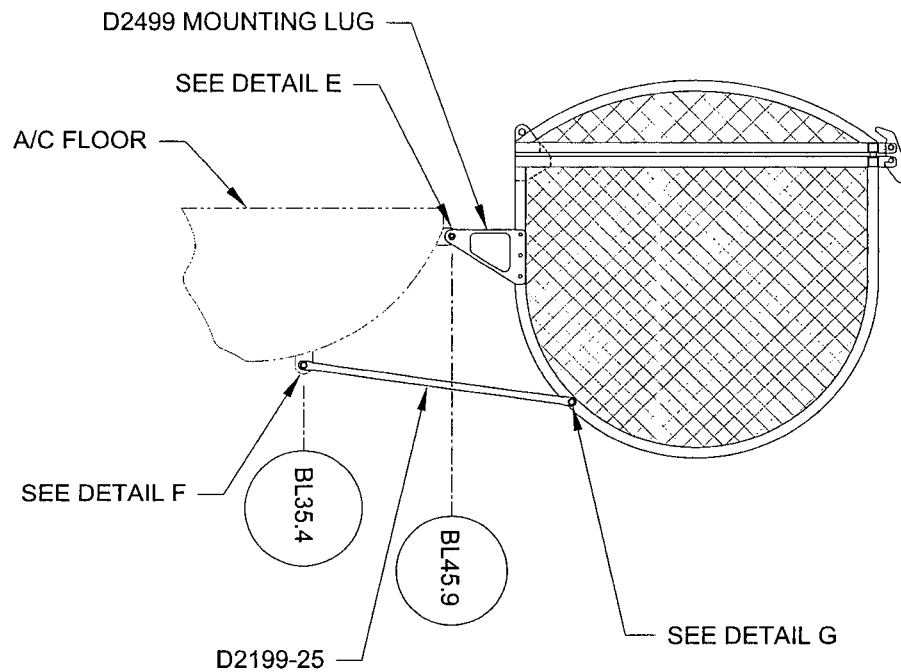


Figure 4a – Section C-C Looking Fwd at STA 155.06

(D205-541-044 Shown; D205-541-043 Opposite)

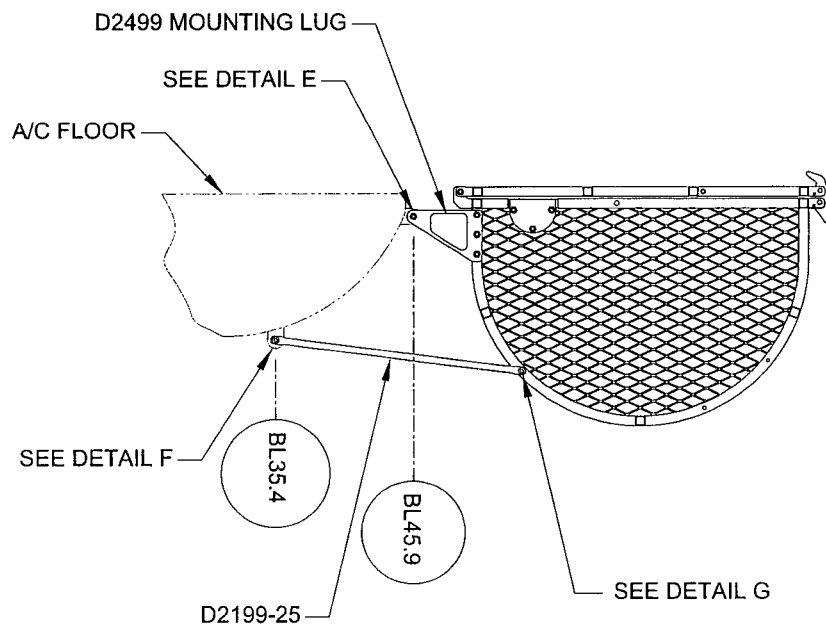


Figure 4b – Section C-C Looking Fwd at STA 155.06

(D205-541-046 Shown; D205-541-045 Opposite)

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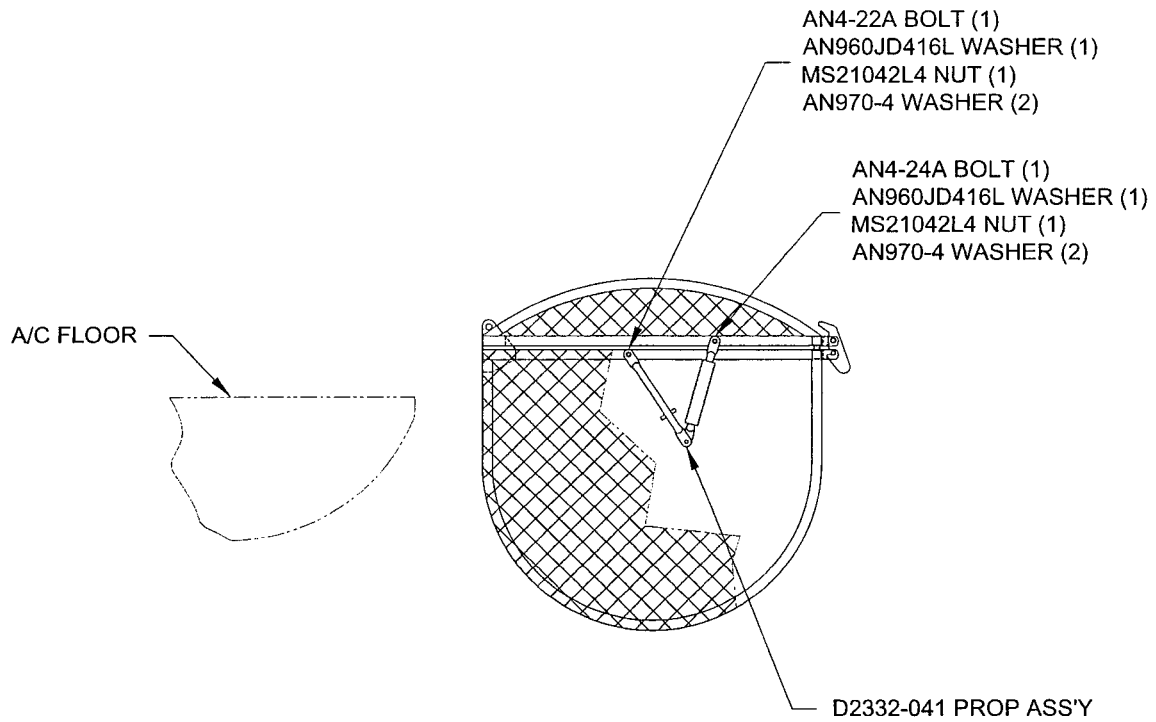


Figure 5a – Section D-D Looking Fwd at STA 180.08

(D205-541-044 Shown; D205-541-043 Opposite)

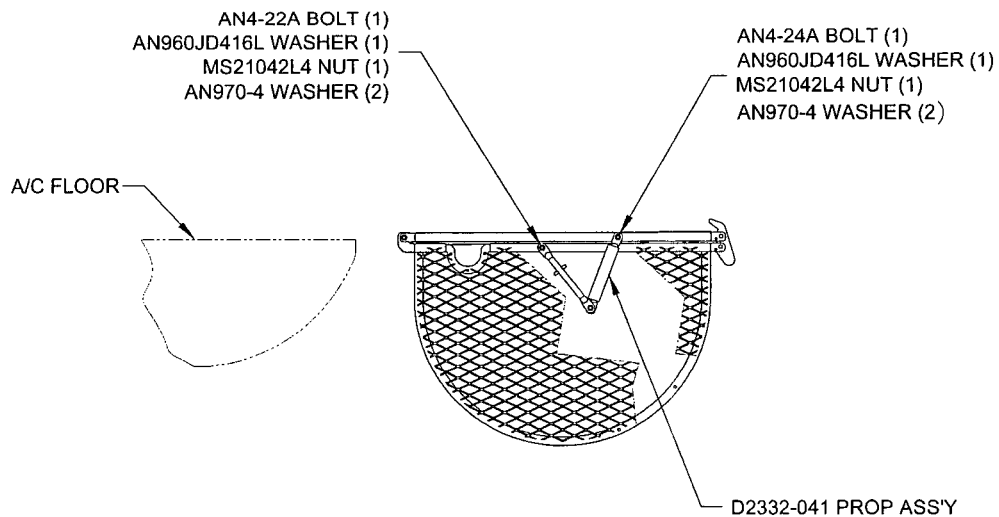


Figure 5b – Section D-D Looking Fwd at STA 180.08

(D205-541-046 Shown; D205-541-045 Opposite)

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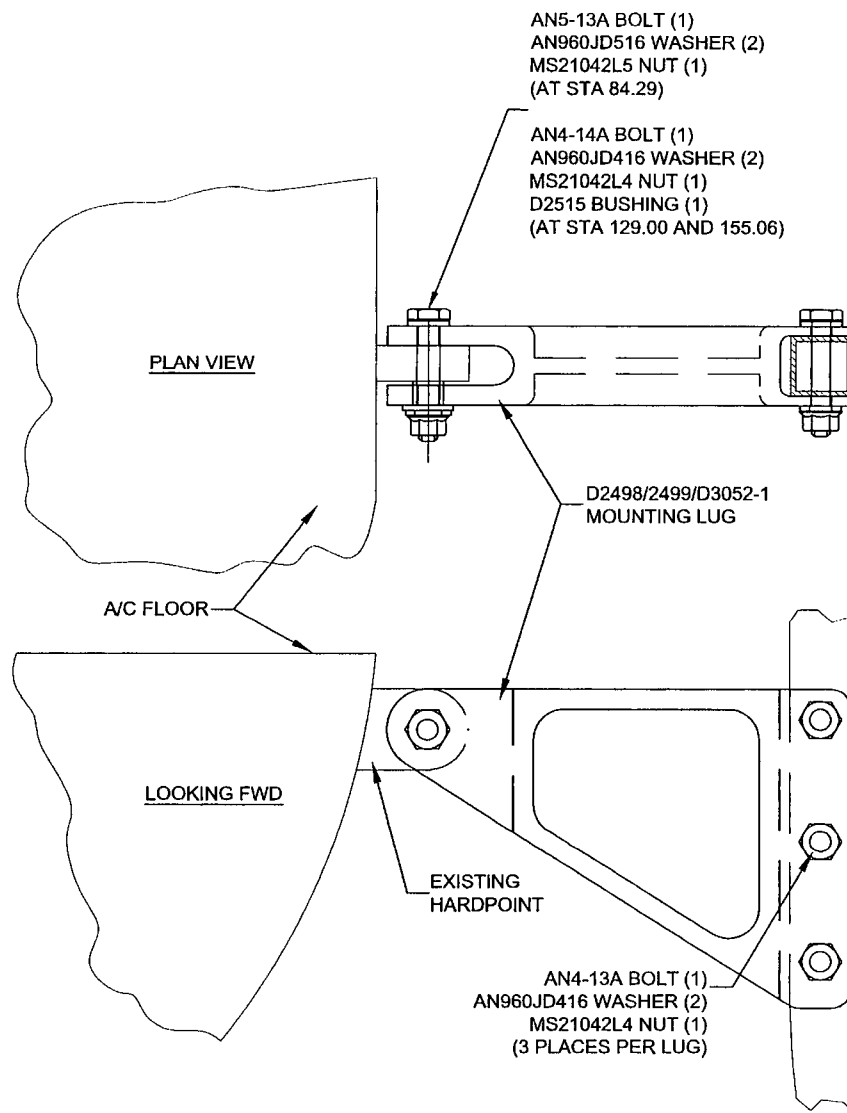


Figure 6 – Detail 'E' Mounting Lug Installation

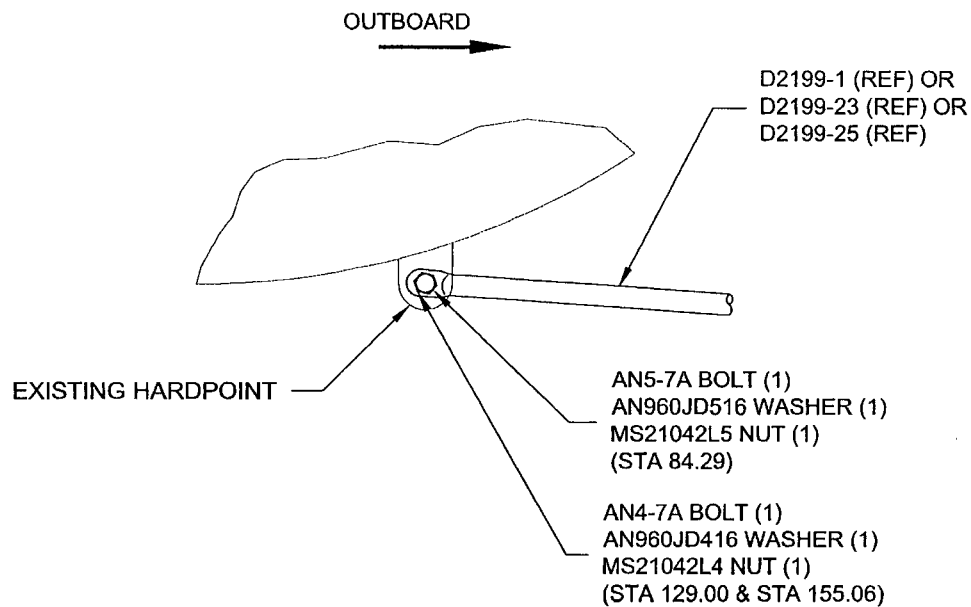


Figure 7 – Detail 'F' Strut to Hardpoint Attachment
(D205-541-044 & D205-541-046 Shown; D205-541-043 & D205-541-045 Opposite)

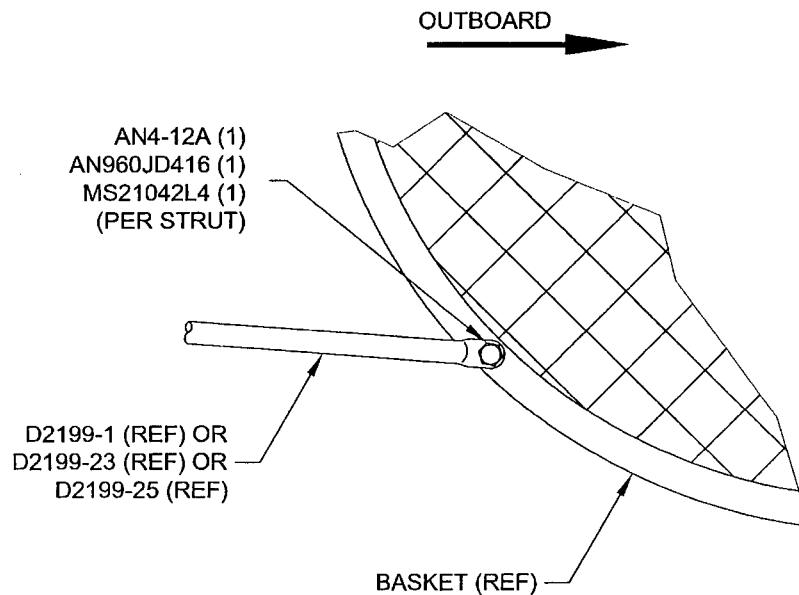


Figure 8 – Detail 'G' Strut to Basket Attachment
(D205-541-044 & D205-541-046 Shown; D205-541-043 & D205-541-045 Opposite)

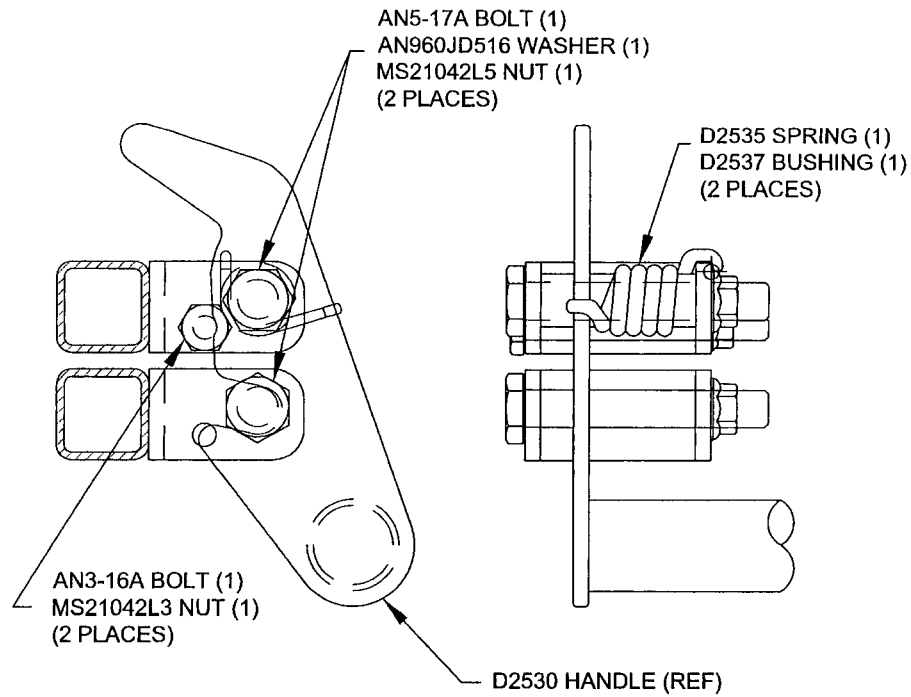


Figure 9 – Detail 'H' Handle Assembly

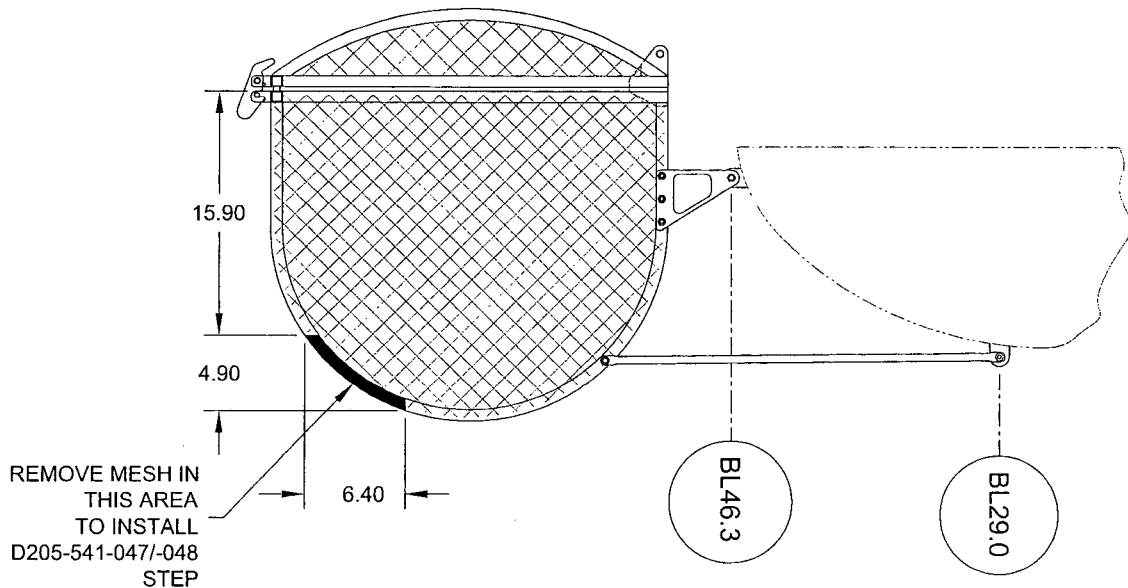


Figure 10 – Mesh Removal Looking Aft at STA 84.00
(D205-541-044 Shown; D205-541-043 Opposite)